

Work Order ID 100060

4/17/13 1:07:20 PM

\*100060\*

Page 1

Item ID: D4001-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Fitting

Stop

\*NS2\*

Start Date: 4/17/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: M65

Date: 1304-17 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4001	A								
100		0.00							
*100*									
Lathe Conv	Memo	0.00							
Conventional Lathe	I-Turn as per dwg								
	DEBURR								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
*120*									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
*130*									
QC	Memo	0.00							
Quality Control									

at/MWP 13/04/24

6 φ

at/MWP 13/04/24

6 φ

PD/D.a 13/04/25

6 φ

DAS  
08  
9-89

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order:			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
			Rework	Skid-tube	Crosstube	Water Jet	Engineering								
			Scrap	Machining	Small Fab	Prod. Eng. Coor.	Quality								
			Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other								
			Work Order Update	Large Fab	Composite	Supplier									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							

**Work Order ID 100060**

April 17-13 1:07:20 PM

**\*100060\***

Page 2

Item ID: D4001-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Fitting

Stop

**\*NS2\***

Start Date: 4/17/13 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
131 <b>*131*</b> HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							6 4/13-4/25
Hand Finishing	Memo brush alodine as per dwg *****do not acid etch*****	0.00							
132 <b>*132*</b> QC	QC3- Inspect Part Finish	0.00	0AS 27	0AS 27				6	
Quality Control	Memo	0.00	B4QS						
140 <b>*140*</b> Packaging	Identify as per dwg & Stock Location: <u>57243</u>	0.00							<u>4/13/13 (e)</u>
Packaging	Memo	0.00							

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
	<input type="checkbox"/>	Bending	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced			
	<input type="checkbox"/>	Centre Not Concentric to O/S	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure			
	<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damaged	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld			
	<input type="checkbox"/>	Crushed/Crimped	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled			
	<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>				
	<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>				
	<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other			
	<input type="checkbox"/>	Ripples in Bend	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>		<input type="checkbox"/>				
	<input type="checkbox"/>	Torque Waves in Extrusion	<input type="checkbox"/>	Drawing	<input type="checkbox"/>		<input type="checkbox"/>				
	<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>		<input type="checkbox"/>				
	<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Folio	<input type="checkbox"/>		<input type="checkbox"/>				

Work Order ID 100060

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\*100060\*

Page 3

Item ID: D4001-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Fitting

Stop

\*NS2\*

Start Date: 4/17/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

13/5/13 20

\*150\*

QC

Memo

0.00

MF  
13-4-29

Quality Control

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order:	DISPOSITION				AGAINST DEPARTMENT/PROCESS				
Part No.:	Rework	Scrap	Use-as-is	Work Order Update	Skid-tube	Machining	Crosstube	Water Jet	Engineering
NCR No.:					Thermoforming	Large Fab	Small Fab	Prod. Eng. Coor.	Quality
					Composite		Finishing	Rec/Store/Packaging	Other
								Supplier	
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									
FAULT CATEGORY									
Landing Gear			General						
			Bending	Grain	Ovalized	Pressure/Forced			
			Centre Not Concentric to O/S	BOM/Route	Over/Under tolerance	Temperature/Cure			
			Cracks	Broken/Damaged	Part Incorrect	Weld			
			Crushed/Crimped.	Burrs	Part Lost/Missing	Wrong Stock Pulled			
			Cuffs	Contamination	Part Moved				
			Heat Treat	Countersink	Positioned Wrong				
			Inspection Strip in Tube	Cut Too Short	Power Loss/Surge				
			Ripples in Bend	Drill Holes					
			Torque Waves in Extrusion	Drawing					
			Turning Sequence	Finish					
			Wave/Twist in Tube	Folio					

## PICKLIST PRINT

April-17-13 11:07:23 PM

Page 1

Work Order ID: 100060

Parent Item: D4001-3

Parent Item Name: Fitting

**\*100060\***  
**\*D4001-3\***

Start Date: 4/17/13

Required Date: 5/01/13

Start Qty: 6.00

Required Qty: 6.00

**Comments:** IPP rev A 09.12.23 new issue Prelim EC verified by:DD IPP rev B  
10.05.13 ecn10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN832-6D		Purchased	No				Each	8.0000		6			

**\*AN832-6D\***

UNION

Location	Loc Qty	Loc Code
ST324	8	
11474	1	
120693	7	

*JK*  
*MWP 13/04/24*

*MWP*

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

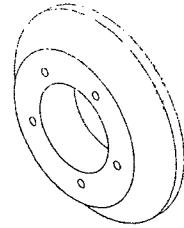
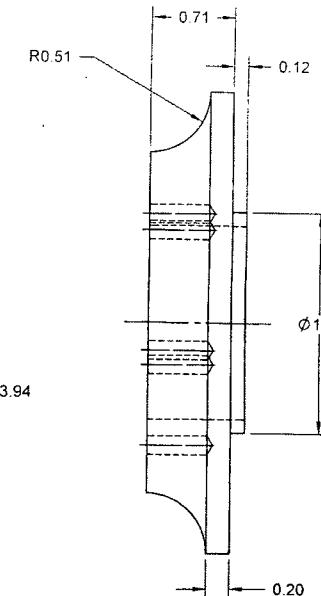
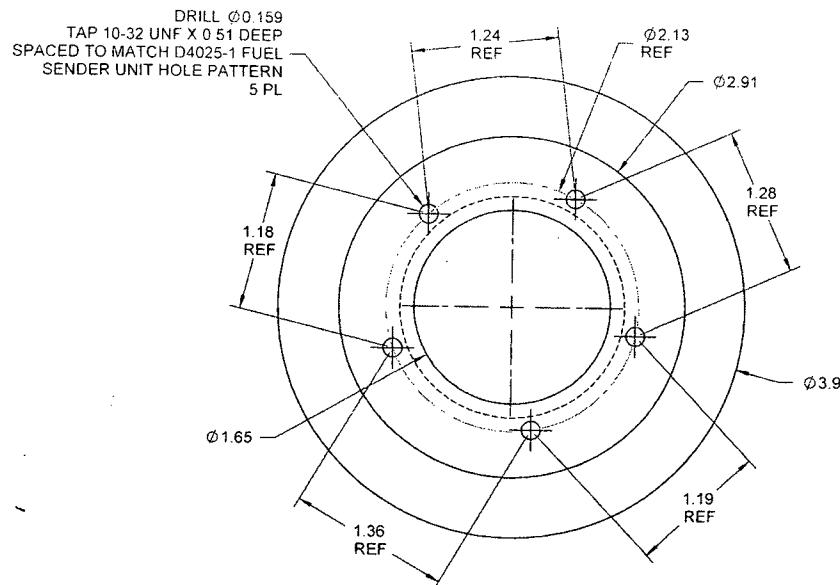
Work Order:			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework	Skid-tube	Crosstube	Water Jet	Engineering				
			Scrap	Machining	Small Fab	Prod. Eng. Coor.	Quality				
			Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other				
			Work Order Update	Large Fab	Composite	Supplier					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bend	Grain	Ovalized	Pressure/Forced				
				BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure				
				Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld				
				Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled				
				Contamination	Maintenance	Part Moved					
				Countersink	Mislabeled	Positioned Wrong					
				Cut Too Short	Misread	Power Loss/Surge	Other				
				Drill Holes	Offset						
				Drawing	Out of Calibration						
				Finish	Out of Sequence						
				Folio	Outside Dimensions						

DART AEROSPACE LTD	Work Order:	100060
Description: Fitting	Part Number:	D4001-3
Inspection Dwg: D4001	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<u>Mud /xyz</u>	Audited by:	<u>PD/b.a</u> <u>DAS</u> <u>08</u> <u>9-89</u>	Preliminary Approval:	
Date:	<u>13/04/24</u>	Date:	<u>13/04/25</u>	Date:	

Rev	Date	Change	Revised by	Approved
A	11.01.17	New Issue	KJ	



STL 100060  
100060.M05  
13-04-17  
UNCOM 100060.M05  
100060.M05  
100060.M05  
100060.M05  
100060.M05

13-04-17

**D4001-1 FITTING**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

8      7      6      5      4      3      2

A	NEW ISSUE	REV.	DESCRIPTION	BY	DATE
			DART AEROSPACE LTD		10.02.05
			HAWKESBURY, ONTARIO, CANADA		
			DRAWING NO.	REV. A	
			D4001		SHEET 1 OF 2
			MFG. APPR.		
			APPROVED		SCALE
			DE APPR.		NTS
			DATE	10.02.05	

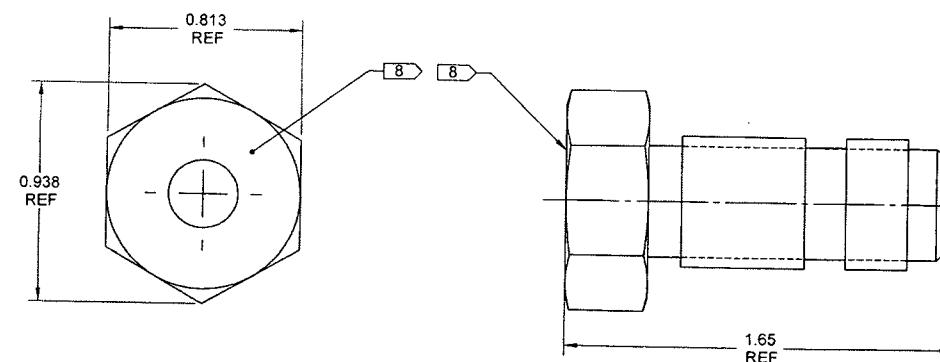
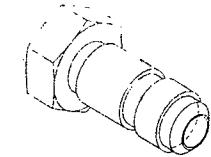
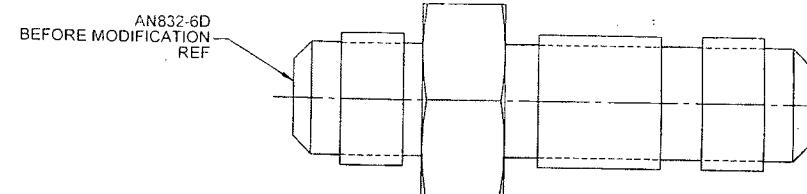
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WRITTEN PERMISSION FROM DART AEROSPACE LTD

**RELEASED**  
2010-05-05  
MM

100060

DART AEROSPACE  
PART NUMBERJOHN CAMERON AVIATION  
PART NUMBER

JAM 17-2

JCA M47 2-28  
(AN832-6D JCA)D4001-3 FITTING

## NOTES:

- 1) MATERIAL: MADE FROM AN832-6D
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4001-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs
- 8) BRUSH ALODINE MACHINED SURFACE

8 1 7 6 5 4 3 2 1

DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	
MFG. APPR.	<i>AB</i>	
APPROVED	<i>AB</i>	
DE APPR.	<i>AB</i>	
DATE	10.02.05	
DRAWING NO.	D4001	REV. A
TITLE	FITTING	SCALE
		NTS
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